

# Work Order ID 53202

October 26, 2009 12:41:54 PM



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Item ID:	D2512	Accept		Setup	Start	
Revision ID:	E				Stop	
Item Name:	Basket Lid 205/350					
Start Date:	26/10/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	04/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	09-10-26	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2512	Rev E								
100	Weld per dwg A/R S.S. rod Batch: <u>M109213</u>	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut 3/4" x 3/4" square tubing as per Dwg D2512								
	2-Cut (4) D2236 From D3166-3								
	3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305								
	4-Weld as per Dwg D2512 using Welding Jig DT 9436								
	Deburr as required								
	***INSTALL D2012-117 CLEVIS ONLY ON D130-701-041***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

09 10 30

09.11.02



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Start Date:	26/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	04/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:		Run	Start
	QC:	Date:	SPC (Y/N):			Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  HandFinish	HandFinishing	0.00							
Hand Finishing	Memo <i>M 112437 BLACK.</i> Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: <i>M 112106</i>	0.00	<i>BR 09-11-4</i>			<i>①.</i>			
150  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00	<i>MD 0911104</i>			<i>11</i>			
160  Packaging	Identify as per dwg & Stock Location: <i>PNP</i>	0.00							
Packaging	Memo	0.00				<i>B52036</i>	<i>09/11/08C</i>		

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Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev. Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/04

PL 09-11-5

# Picklist Print

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Work Order ID: 53202



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2012-117RevC Manufactured No



Clevis

*Handwritten: A, C, 041*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

24

31101

2

52498

22

\*\*\*ONLY APPLICABLE ON D130701-HZ\*\*\*

D2232-1RevC Manufactured No



Basket Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

48230

2

Main Warehouse

WA

24

50896 ✓

4

51105

20

*Handwritten: 2009.10.27*

# Picklist Print

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Work Order ID: 53202

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 26/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1RevD		Manufactured	No			100	Each	41.0000	2.0000			



Spacer Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	41	
51331 ✓	16	
52832	25	

② 09.10.27

D2506RevF

Manufactured No



Label Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
44275	1	
Main Warehouse		
WA	12	
51303 ✓	2	
52834	10	

① 09.10.27

# Picklist Print

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Work Order ID: 53202

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350



Start Date: 26/10/2009

Required Date: 04/11/2009



Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1  Mounting Bracket		Manufactured	No			100	Each	66.0000	2.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
46086	2	
48428	1	
51120	10	
Main Warehouse		
WA	53	
50872	4	
51745 ✓	49	

✓ D3166-3RevA1  Basket Hoop		Manufactured	No			100	Each	11.6210	1.0000 			
---	--	--------------	----	--	--	-----	------	---------	--	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	11.621	
50033	0.0527	
50618	0.5683	
51249	5	
52058	6	

② 09-10-27  
SAD 09-10-27

# Picklist Print

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Work Order ID: 53202

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350



Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ M304EX0.75-16F  Expanded Metal Flat SS		Purchased	No			100	sf	476.5700	18.9474		 <u>SAD 09-10-28</u>	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	476.5700065	
110134	3.4	
111630	5.85	<u>2.00</u>
111956	0.000017	
112147	8.29428947	
112311	28.9205	
112707	110.1052	<u>16.9474</u>
112949	320	

M304TS0.750W.065

Purchased

No

100 f

460.8319 45.8741



304 SQ Tube .75x.75x.065W



SAD 09-10-27

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	460.8318947	
112398	460.831895	<u>45.8741</u>

Scrap End Bar B# 112398 Qty 0.75g (ft)

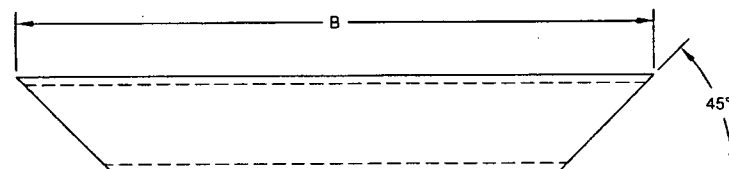
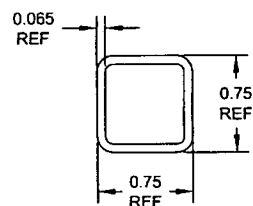
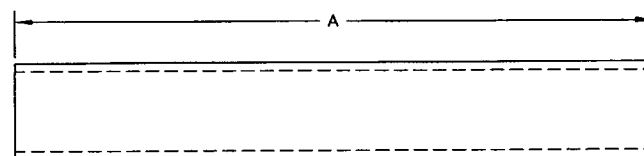
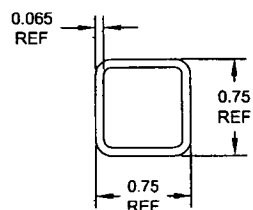


# 8 7 6 5 4 3 2 1 **PARTS LIST FOR D2512 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

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WORK ORDER  
NO. 53202

*09-10-26*



**RELEASED**  
*08-08-21*

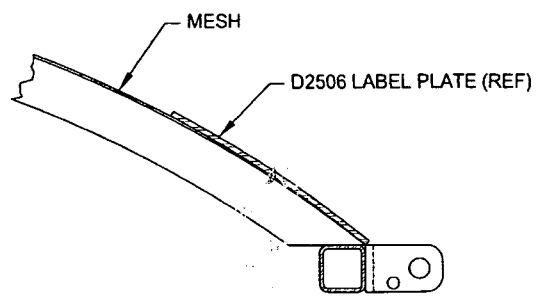
**E**

## **D2512-1/-3/-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW.	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

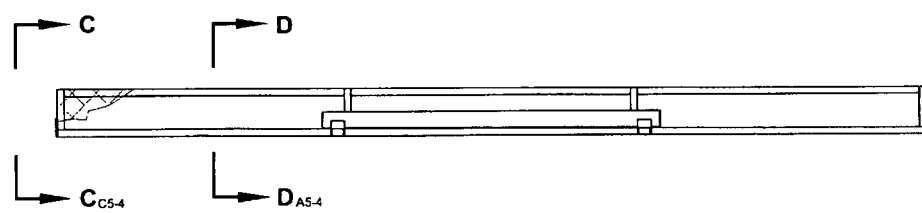
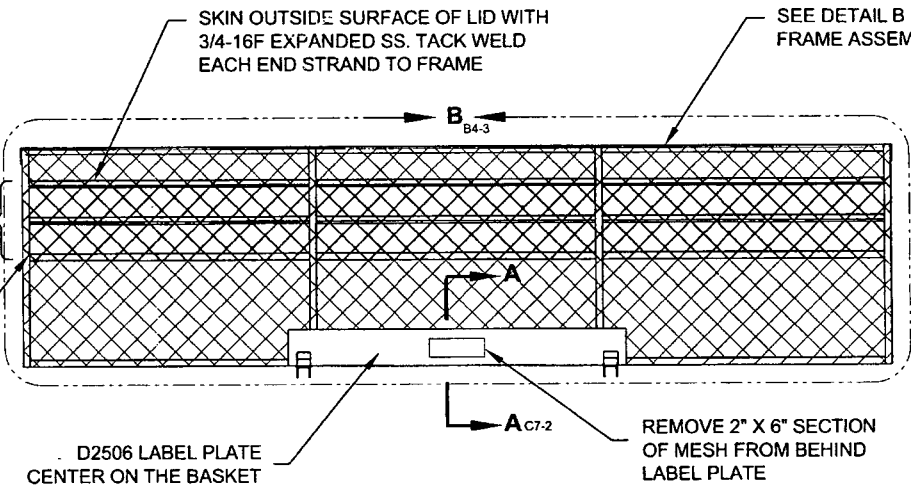
UNCO  
SUBJEC  
WIT.  
WO.  
53202



**SECTION A-A**<sub>B3-2</sub>  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

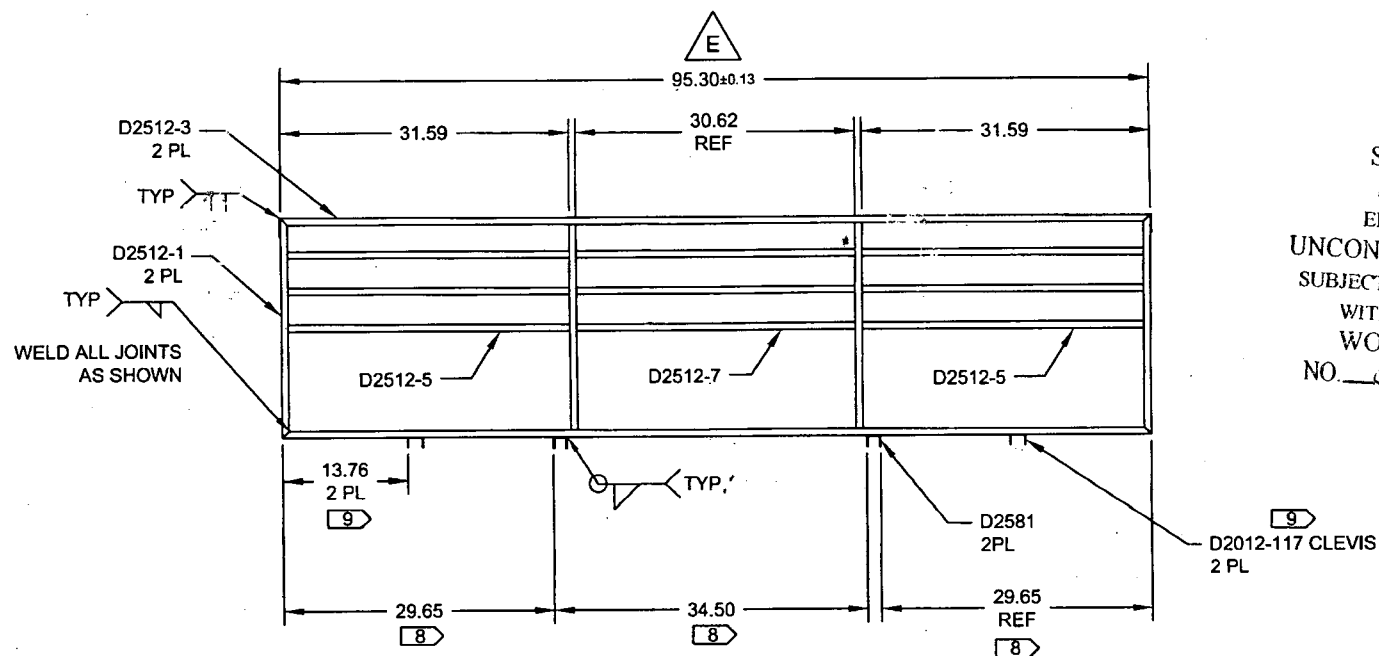
TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



**RELEASED**  
08-08-21/11

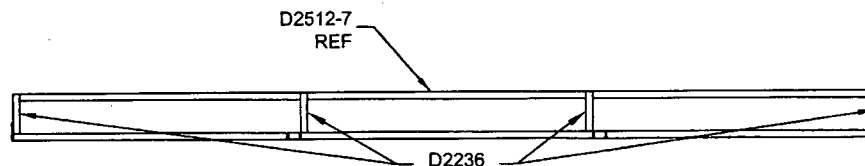
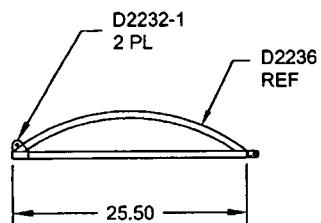
- D2512 BASKET LID ASSEMBLY NOTES:**
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
  - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
  - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK SHARP EDGES: N/A
  - 7) IDENTIFICATION: NONE
  - 8) WEIGHT: N/A
  - 9) WELD PER DART QSI 004

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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**DETAIL B** C3-2  
FRAMEWORK ONLY SHOWN FOR CLARITY



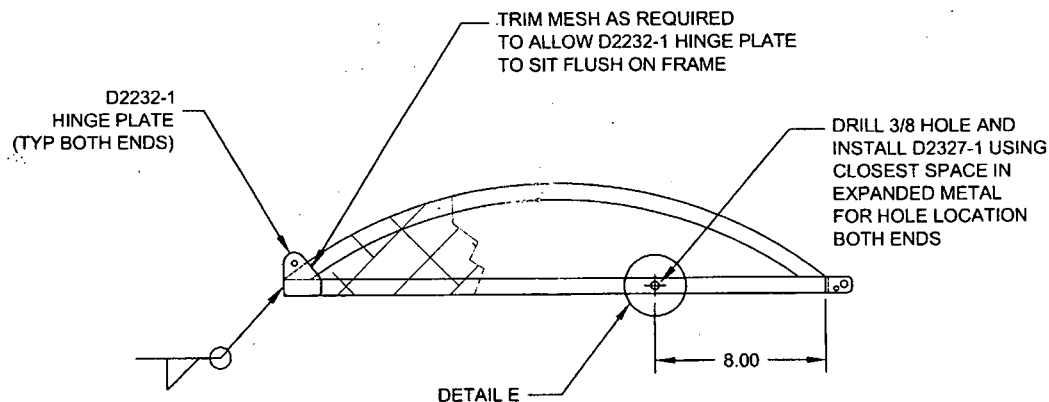
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**NOTES:**

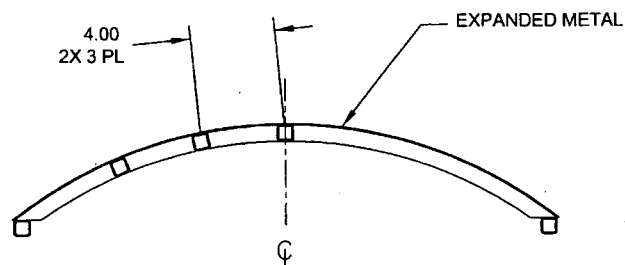
MATERIAL: NONE  
FINISH: NONE  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: N/A  
IDENTIFICATION: NONE  
WEIGHT: N/A  
LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY  
FOR D130-701-041 ONLY

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

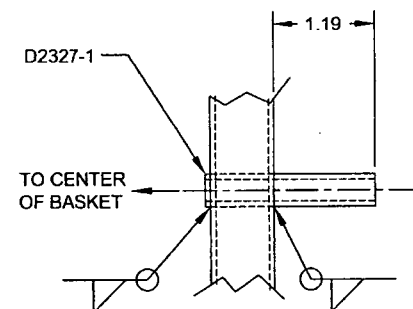


**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2

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WORK ORDER  
NO. 53202



**DETAIL E** C6-4

**RELEASED**  
08.06.17

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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